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D5134-042
Job Sheet 182318



Part No: D5134-042

Job Qty: 10 ea

Part Name: Damper Support Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/22/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Machining-3		SBL 18/09/18
100	Bandsaw	10 pcs	9/7/18	9/7/18	0.00	0.40	Bandsaw1		SBL 18/09/18
110	CNC Vertical Machining	10 pcs	9/7/18	9/7/18	0.63	23.26	HAAS1-4		SBL 18/09/18
120	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC2 Machining-3		SBL 18/09/18
130	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC8 Machining-3		18-09-19
135	HandFinish	10 pcs	9/7/18	9/7/18	0.00	0.83	HandFinish1		D.R 18/09/19
137	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC7-4		AB SEP 20 2018
140	SprayPaint	10 pcs	9/7/18	9/7/18	0.00	1.67	Spray Paint		AB SEP 20 2018
150	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC14		SEP 24 2018 68
160	Small Fab	10 pcs	9/7/18	9/7/18	0.00	2.11	Small Fab-8		9-89
170	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC5		38
180	Packaging	10 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-2 LG054		AB SEP 24 2018
190	QC21-SA	10 Ea	9/7/18	9/7/18	0.00	0.00	QC21		HLJ 18-09-19

Part Op 100 - CUT BLANK TO 5.125" LONG

Descriptions: 110 - Mill as per Dwg and folio FB342 DWG REV: _____ FOLIO REV: _____ DEBURR

Prime 138877 Paint 138949

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B3.000X4.000	7075-T73 Bar 3.0 X 4.0 Grain Direction Along 3"	4.3000 ft (.43 ea)	90-Start up Operation	S107551
NAS77C6-021	Bushing	20 Ea (2 ea)	160-Small Fab	fmB4833

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B3.000X4.000	4	21	0
160-Small Fab	NAS77C6-021	20	251	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Damper Support, RH	0.360Inches ± 0.030	0.390 0.330		
2	Damper Support, RH	0.188Inches + 0.005 - 0.001	0.193 0.187		

3	Damper Support, RH	0.257Inches $\begin{smallmatrix} + 0.006 \\ - 0.001 \end{smallmatrix}$	$\begin{smallmatrix} 0.263 \\ 0.256 \end{smallmatrix}$	
4	Damper Support, RH	1.932Inches ± 0.010	$\begin{smallmatrix} 1.942 \\ 1.922 \end{smallmatrix}$	
5	Damper Support, RH	0.632Inches ± 0.010	$\begin{smallmatrix} 0.642 \\ 0.622 \end{smallmatrix}$	
6	Damper Support, RH	0.632Inches ± 0.010	$\begin{smallmatrix} 0.642 \\ 0.622 \end{smallmatrix}$	
7	Damper Support, RH	0.730Inches ± 0.010	$\begin{smallmatrix} 0.740 \\ 0.720 \end{smallmatrix}$	
8	Damper Support, RH	0.500Inches $\begin{smallmatrix} + 0.000 \\ - 0.001 \end{smallmatrix}$	$\begin{smallmatrix} 0.500 \\ 0.499 \end{smallmatrix}$	
9	Damper Support, RH	0.100Inches ± 0.010	$\begin{smallmatrix} 0.110 \\ 0.090 \end{smallmatrix}$	
10	Damper Support, RH	0.728Inches ± 0.010	$\begin{smallmatrix} 0.738 \\ 0.718 \end{smallmatrix}$	
11	Damper Support, RH	0.250Inches ± 0.030	$\begin{smallmatrix} 0.280 \\ 0.220 \end{smallmatrix}$	Radius
12	Damper Support, RH	0.630Degrees ± 0.030	$\begin{smallmatrix} 0.660 \\ 0.600 \end{smallmatrix}$	Radius
13	Damper Support, RH	0.063Degrees ± 0.010	$\begin{smallmatrix} 0.073 \\ 0.053 \end{smallmatrix}$	Radius
14	Damper Support, RH	0.117Inches ± 0.010	$\begin{smallmatrix} 0.127 \\ 0.107 \end{smallmatrix}$	
15	Damper Support, RH	0.177Inches ± 0.010	$\begin{smallmatrix} 0.187 \\ 0.167 \end{smallmatrix}$	
16	Damper Support, RH	0.841Inches ± 0.010	$\begin{smallmatrix} 0.851 \\ 0.831 \end{smallmatrix}$	
17	Damper Support, RH	0.208Inches ± 0.010	$\begin{smallmatrix} 0.218 \\ 0.198 \end{smallmatrix}$	
18	Damper Support, RH	0Degrees ± 0	$\begin{smallmatrix} 0 \\ 0 \end{smallmatrix}$	
19	Damper Support, RH	0.860Inches ± 0.010	$\begin{smallmatrix} 0.870 \\ 0.850 \end{smallmatrix}$	
20	Damper Support, RH	1.471Inches ± 0.010	$\begin{smallmatrix} 1.481 \\ 1.461 \end{smallmatrix}$	
21	Damper Support, RH	0.130Inches ± 0.030	$\begin{smallmatrix} 0.160 \\ 0.100 \end{smallmatrix}$	Radius

Plex 8/22/18 12:58 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

NCR No. 19-7299

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐



MD
11 Jul 2019

Job: <u>182318</u>		DEPARTMENT/PROCESS			
Part No. <u>DS134-042</u>		Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date: <u>18/9/17</u>	Sequence #: _____	QTY Affected: _____		MRB (Q51042) DAS 12 18/9/17 9-89	
Description Work Order Deviation		Disposition			
Dm 0.841 is under tolerance, up to 0.827.		Acceptable. No effect on strength or function of the damper. Check-fit with OEM showed no effect on fit.			
Completed By DAS 12 18/9/17 9-89 Lead hand / Supervisor D.E 18-09-19		Lead hand / Supervisor D.E 18-09-19			
PS / QA Coordinator DAS 55 9-89 19-7-11		PS / QA Coordinator DAS 55 9-89 19-7-11			
Root Cause ☒ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			